



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

AUG 14 2018

005177

D119-675-112
Job Sheet 181779



Part No: D119-675-112

Job Qty: 2 ea

Part Name: Heli-Access-Step™ RH - DART Crosstube Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/8/18

Job Tracking No:

Due Date: 10/24/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP REV:A 15.11.09 PER IIN REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time
					Setup hrs	Run Hrs	Workcenter / Supplier		
90	Start up Operation	2 Ea	10/24/18	10/24/18	0.00	0.00	Start Up Stores/Pkg-1		
110	Packaging	2 pcs	10/24/18	10/24/18	0.00	0.00	Packaging1-1		
120	QC	2 pcs	10/24/18	10/24/18	0.00	0.00	QC4		
125	DC	2 pcs	10/24/18	10/24/18	0.00	0.00	DC		
130	Packaging	2 pcs	10/24/18	10/24/18	0.00	0.00	Packaging3-1		
140	QC21-FG	2 Ea	10/24/18	10/24/18	0.00	0.00	QC21		

Part Op 125 - Photocopy bluefile & type labels per PPP D119-675-112 CHG001
Descriptions: 130 - Identify and pack for shipping as per PPP D119-675-112 Location : FG081

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-15A	Bolt	8 Ea (4 ea)	90-Start up Operation	5083012
AN4-16A	Bolt	8 Ea (4 ea)	90-Start up Operation	5082909X3 5076001X5
AN4-22A	Bolt	8 Ea (4 ea)	90-Start up Operation	5097470
D2617-3	Bushing	8 Ea (4 ea)	90-Start up Operation	5142939X5 5116369X3
D2617-5	Spacer	8 Ea (4 ea)	90-Start up Operation	5140802
D2732-032	Rubber Cushion - 3.2"	16 Ea (8 ea)	90-Start up Operation	5102362X9
D3043-042	Step Weldment RH	2 Ea (1 ea)	90-Start up Operation	5108470
D5283-041	Basket Clamp Assembly	4 Ea (2 ea)	90-Start up Operation	5102174
D5283-043	Basket Clamp Assembly	4 Ea (2 ea)	90-Start up Operation	5085158
D5283-11	Basket Clamp	4 Ea (2 ea)	90-Start up Operation	5101261
D5283-7	Basket Clamp	4 Ea (2 ea)	90-Start up Operation	5102247
MS21042L4	Nut	24 Ea (12 ea)	90-Start up Operation	5089365
NAS1149D0463J	Washer	48 Ea (24 ea)	90-Start up Operation	5089294

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-15A	8	413	0
	AN4-16A	8	709	0
	AN4-22A	8	246	0
	D2617-3	8	23	0
	D2617-5	8	47	0
	D2732-032	16	51	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Description Work Order				Disposition																																																																			
Dart Aerospace Ltd. 1270 Aberdeen Street Danbury, ON V6A 1K7 CANADA TEL: 1-813-632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S116775 Part: D119-675-112 Job No: 181779 Serial No/Batch: S116775 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: FAA STC SR00948SE 15/10/2016 LoA C-11								Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																															
Root Cause <table style="width:100%; border: none;"> <tr> <td style="width:50%;">Environment ☐</td> <td style="width:50%;">No Re-verification ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> </tr> </table>				Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%; border: none;"> <tr> <td style="width:50%;">re/Cure ☐</td> <td style="width:50%;">Power Loss/Surge ☐</td> </tr> <tr> <td>e ☐</td> <td>Folio/Program ☐</td> </tr> <tr> <td>mage/Defect ☐</td> <td>Grain ☐</td> </tr> <tr> <td>Incomplete/Unqualified ☐</td> <td>Weld ☐</td> </tr> <tr> <td></td> <td>Wrong Stock Pulled ☐</td> </tr> <tr> <td></td> <td>Out of Sequence ☐</td> </tr> <tr> <td></td> <td>Off-set ☐</td> </tr> <tr> <td></td> <td>Mislabeled ☐</td> </tr> <tr> <td></td> <td>Fit/Function ☐</td> </tr> <tr> <td></td> <td>Misaligned/off center ☐</td> </tr> <tr> <td></td> <td>Positioned Wrong ☐</td> </tr> <tr> <td></td> <td>Outside Dimensions ☐</td> </tr> <tr> <td></td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td></td> <td>Part Incorrect ☐</td> </tr> <tr> <td></td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td></td> <td>Part Moved ☐</td> </tr> <tr> <td></td> <td>Drawing ☐</td> </tr> <tr> <td></td> <td>Finish ☐</td> </tr> <tr> <td></td> <td>Misread ☐</td> </tr> <tr> <td></td> <td>Turning Sequence ☐</td> </tr> </table>				re/Cure ☐	Power Loss/Surge ☐	e ☐	Folio/Program ☐	mage/Defect ☐	Grain ☐	Incomplete/Unqualified ☐	Weld ☐		Wrong Stock Pulled ☐		Out of Sequence ☐		Off-set ☐		Mislabeled ☐		Fit/Function ☐		Misaligned/off center ☐		Positioned Wrong ☐		Outside Dimensions ☐		Over/Under tolerance ☐		Part Incorrect ☐		Part Lost/Missing ☐		Part Moved ☐		Drawing ☐		Finish ☐		Misread ☐		Turning Sequence ☐
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D3043-042	2	0	0
D5283-041	4	15	0
D5283-043	4	9	0
D5283-11	4	11	0
D5283-7	4	11	0
MS21042L4	24	6,194	0
NAS1149D0463J	48	10,335	0

Part Specifications

Specifications could not be found.

Plex 8/8/18 12:53 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

5.0 PARTS LISTS

5.1 Heli-Access-Step™ Parts List

ITEM	Qty -011	Qty -012	Qty -111	Qty -112	Part Number	Description
	X				D119-675-011	HELI-ACCESS-STEP™, LH
		X			D119-675-012	HELI-ACCESS-STEP™, RH
			X		D119-675-111	HELI-ACCESS-STEP™, LH
				X	D119-675-112	HELI-ACCESS-STEP™, RH
1	4	4	4	4	D2617-5	BUSHING
2	4	4	4	4	D2617-3	BUSHING
3	8	8	8	8	D2732-032	RUBBER CUSHION
4	1		1		D3043-041	STEP WELDMENT LH
5		1		1	D3043-042	STEP WELDMENT RH
6	4	4			D3041-1	CLAMP
7	2	2			D3041-3	CLAMP
8	4	4			D3041-5	CLAMP
9	2	2			D3041-7	CLAMP
10			2	2	D5283-7	CLAMP
11			2	2	D5283-11	CLAMP
12			2	2	D5283-041	CLAMP
13			2	2	D5283-043	CLAMP
14	4	4	4	4	AN4-15A	BOLT
15	8	8	4	4	AN4-16A	BOLT
16			4	4	AN4-22A	BOLT
17	24	24	24	24	NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

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Revision: C

Date: 15.07.20

Change Record

PAGE 1 OF 1

Part Number: D119-675-111/-112

Description: HELI ACCESS STEP, LH/RH

[illegible]